Work Order ID 101559 -/ *101559* Page 1 May-13-13 1:04:49 PM *N900040100* D3235-1 Accept Item ID: Setup Start Revision ID: Mounting Lug Item Name: Start Qty: 200.00 Start Date: 5/13/13 Cust Item ID: Reg'd Oty: 200.00 Required Date: 5/31/13 Customer: Reference: Run cx Date: 13/05/14 Tooling: Process Plan: Approvals: Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool# Set Up/ Plan Accept Reject Reject Insp. Work Center ID Description Code Otv Otv Number Stamp Run Hours Draw Nbr Revision Nbr D3235 Rev A 100 0.00 BAND SAW (X 13/05/14 200 *100* 0.00 Bandsaw Memo Cut D2423 extrasion to 0.820" Jeaspa Bandsaw cutto meter 0.00 110 HAAS CNC VERTICAL MACHINING #1 CZ 13/05/14 200 0.00 HAAS CNC vertical machine # 1-Machine as per Folio FA369 and Dwg D3235 2-Identify as D3235-1 3-Deburr Ussee Ploto metro muchiheasperdug Rev. A 120 QC2- Inspect parts off-machine FAI/FAIB 0.00 Memo

attached eafeto wio

100x 8PB-5-24

										DQA:	Date:	
NCR: Ye	es / No				WORK ORDER NON-	COI	NFORM	//ANCE / UP	DATE	QA Closed:	Date:	
Work Order					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part No	o			_	Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				and the second second	tion of work order update		Initial		tion	Sign &	MINI TOTAL POP	
Cause	Date	Step	Qty	10	Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
						FAUL	T CATE	GORY				4
Landing	g Gear				General		-0		4			
	Cracks	ot Conce /Crimped	ntric to O	/s	Bend BOM/Route Broken/Damaged Burrs Contamination		-	on Incomplete ions Incomplete/	Unclear	Ovalized Over/Under Part Incorrec Part Lost/Mi Part Moved	et	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	Heat Tre	at			Countersink		Mislabe		-	Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

101559

Page 2

Insp.

Stamp

May-13-13 1:04:49 PM Item ID: D3235-1 Accept *N900040100* Setup Start Revision ID: Item Name: Mounting Lug Start Qty: 200.00 *200* Start Date: 5/13/13 Cust Item ID: Req'd Qty: 200.00 Required Date: 5/31/13 *200* Customer: Reference: Run Start Process Plan: Approvals: Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool # Plan Accept Reject Reject Set Up/ Work Center ID Description Run Hours Code Qty Qty Number QC8-Inspect parts - second check 130 0.00 1000 *130* 0.00 Memo Quality Control Chemical Conversion Coat per QSI005 4.1 0.00 140 \$00 NG13.5:28 *140* HandFinish 0.00 Memo Hand Finishing 160 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00 *160* Powdercoat Memo START TIME: Powder Coating OVEN TEMPERATURE:

M125620

4:0)

FINISH TIME:

100x 1 m-f13/55/29

										DQA:	Date:	
NCR: Y	res / No				WORK ORDER NON	I-COI	NFORN	MANCE / UP	DATE	QA Closed:	Date:	
Work Orde)r:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	No				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved			-	١			T CATE	CORV				
	pa Parameter					FAUL	LT CATE	JORY				
Landi	Cracks	lot Conce /Crimped		0/5	General Bend BOM/Route Broken/Damaged Burrs Contamination			on Incomplete ions Incomplete/	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
1	Heat Tre	at			Countersink	-	Mislabe		-	Positioned V	Vrong	
52. 0		on Strip in	Tube		Cut Too Short		Misread			Power Loss/		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

Work Order ID 101559

101559

Page 3

Item ID:

. . .

D3235-1

Accept

Setup Start

Revision ID:

Item Name:

Mounting Lug

Start Date: 5/13/13 Required Date: 5/31/13

200

200

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Date:

Date:

N900040100

Run Start

Stop

Sequence ID/ Work Center ID

170

170

Operation

Description

Memo

QC3- Inspect Part Finish

0.00

0.00

Quality Control

180

120

Packaging Packaging

Memo

Identify as per dwg & Stock Location: 57970 0.00

0.00

190

190 QC Quality Control QC21- Final Inspection - Work Order Release

0.00

0.00

MLJ 13-06-12

Memo

May-13-13 1:04:49 PM

Start Oty: 200.00

Req'd Qty: 200.00

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Qty

Insp. Number Stamp

									QA Closed:	Date:	
				DISPOSITION Rework Scrap Use-as-is Work Order Update		Therm	Machining oforming	Crosstube Small Fab Finishing Composite	PARTMENT,	/PROCESS Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
	<u></u>	01	1/15	N 15		itial	Acti		Sign &	Varification	06 Inserted
Date	Step	Qty		or Non-conformance	Chie	er Eng	Descri	ption	Date	Verification	QC Inspector
	-			F	AULT	CATE	GORY				
Bending Centre N Cracks Crushed/ Cuffs Heat Tree Inspection Ripples in	Crimped at on Strip in n Bend Vaves in E	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Hardwar nspection nstruction Mainte Mislabel Misread Offset Out of C	on Incomplete ons Incomplete/U nance led alibration	nclear	Part Incorrect Part Lost/Mis Part Moved Positioned W	tolerance ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Centre N Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in Torque V	Date Step Gear Bending Centre Not Concer Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Ripples in Bend Torque Waves in E	Date Step Qty Gear Bending Centre Not Concentric to C Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend	Date Step Qty Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion	Scrap Use-as-is Work Order Update Date Step Qty Description of work order update or Non-conformance Gear General Bending Bend Centre Not Concentric to O/S Cracks Broken/Damaged Crushed/Crimped Burrs Cuffs Contamination Heat Treat Countersink Inspection Strip in Tube Ripples in Bend Drawing Torque Waves in Extrusion Drawing	Scrap Use-as-is Work Order Update Date Step Qty Description of work order update or Non-conformance FAULT Gear General Bending Bend Centre Not Concentric to O/S BOM/Route Cracks Broken/Damaged In Cracks Crushed/Crimped Burrs Cuffs Contamination Heat Treat Countersink Inspection Strip in Tube Cut Too Short Ripples in Bend Drill Holes Torque Waves in Extrusion Drawing	Scrap Use-as-is Work Order Update Date Step Qty Description of work order update or Non-conformance Chief Eng	Scrap Use-as-is Work Order Update Unitial Acti Date Step Qty Description of work order update or Non-conformance Chief Eng Descri Bending Centre Not Concentric to O/S BOM/Route Cracks Broken/Damaged Crushed/Crimped Burrs Crushed/Crimped Burrs Contamination Heat Treat Inspection Strip in Tube Ripples in Bend Inspection Strip in Tube Ripples in Bend Inspection Incomplete Out of Calibration Drawing Out of Calibration Scrap Wachining Thermoforming Large Fab Instruction Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete/U Misread Offset Out Too Short Misread Offset Out of Calibration	Scrap Use-as-is Work Order Update Use-as-is Work Order Update Use-as-is Work Order Update Use-as-is Use-as-is Work Order Update Use-as-is Use-as-i	Scrap Use-as-is Work Order Update Use-as-is Use-as-is Work Order Update Use-as-is Use-	Scrap Use-as-is Work Order Update Unitial Action Chief Eng Description Of work order update or Non-conformance Chief Eng Description Date Verification Date Step Qty Description of work order update or Non-conformance Initial Chief Eng Description Date Verification

Outside Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

Picklist Print

May-13-13 1:04:49 PM

Work Order ID:

101559

Parent Item:

Comments:

. 1 . .

D3235-1

Parent Item Name:

Mounting Lug

IPP A04.04.19New issueKJ/JLM

Start Date: 5/13/13

Required Date: 5/31/13

Start Qty: 200.00

Required Qty: 200.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423 Lug Extrusion	Story . Ide	Manufactured	No			110	f	588.7400	0.0683	14.37894	CZ 13	10511	4
Dag Estadon				Location		Loc Qty	Lo	c Code					
				MAT006		383			, 55g				
				43722 87953		161.5 221.5							
				Metec		205.74				4.38			
D3235-1P		Purchased	No	93551		205.74	Each	0.0000	1	200			
lug		ruichased	3.356						-	200	01	2 5-	20

										DQA:	Date	
NCR: Yes	/ No				WORK ORDER NON	-co	NFORM	MANCE / UPDATE		QA Closed:	Date	e: .
Work Order:					DISPOSITION			AGAIN	ST DE	PARTMENT	PROCESS	
Part No.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Crosstul Machining Small Fi noforming Finishi Large Fab Composi	ab ng	-	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root				Descr	iption of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance		hief Eng	Description		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier	-			N E								
Training	1											
Unapproved]]
18.8	. 30.3					FAU	LT CATE	GORY			F II	
Landing	Gear		300	7.47	General		-15-51-4	28	_	-		A.
	Bending Centre N Cracks Crushed	ot Conce		o/s	Bend BOM/Route Broken/Damaged Burrs		-	re on Incomplete ons Incomplete/Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi	t	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Contamination

Countersink

Cut Too Short **Drill Holes**

Drawing Finish

Folio

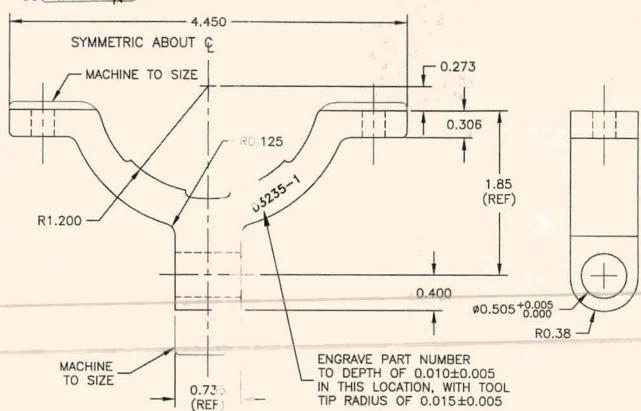
Cuffs

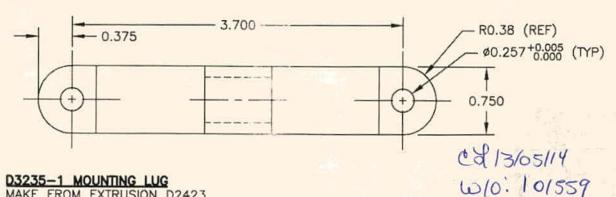
Heat Treat





DESIGN	P DRAWN BY		ROSPACE LTD
CHECKED	APPROVED	DRAWING NO.	REV. A SHEET 1 OF 1
04.03.02	2	MOUNTING LUG	SCALE 1:1
A	04.03.02	NEW ISSUE	No.





D3235-1 MOUNTING LUG

MAKE FROM EXTRUSION D2423 BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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20 Terry Fox Drive Vankleek Hill, Ontario K0B 1R0 , Canada Tel: (613) 678-3957

Fax: (613) 678-3956

Delivery Slip No.:

19232

Date:

May 23, 2013

Page:

1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 19868	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date:

e e ne e roj	Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-3	Mounting Lug as per drawing D2230 REV.G , B101450	Each	300		100
D2230-3	Mounting Lug as per drawing D2230 REV.G, B101495	Each	300	125	175
D2230-1 B101834	Mounting Lug as per drawing D2230-1 REV.G,	Each	320	/	120
D3235-1 B101559	Mounting Lug as per drawing D3235-1 REV.A,	Each	200	600 Sp 13	5-5-24
					<u></u>
			· -=-		
Should there I	goods must be inspected upon receipt to confirm compliance. be discrepancies please notify METEC within 30 days of delivery. e otherwise geemed accepted.	===			

Received by

Thank you for your order!



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

SHIPPED TO:

Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ont.

same

K6A 1K7

QUANTITY	PART NUMBER	PART NAME	P.O. NUMBER
125 100	D2230-3 D3235-1	Mounting Lug Mounting Lug	19868 18986
.00	20200 1	Wooding Lag	10300

MATERIAL: supplied by DART B93551

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

Vankleek Hill, May 23, 2013



Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Tel: 613 632 9577 Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO19868

Purchase Order Date 5/13/2013 PO Print Date 5/14/2013

Page Number 1 of 2

Order From:

VC-MET003

METEC METAL TECHNOLOGY INC. 20 TERRY FOX DRIVE PO BOX 781 VANKLEEK HILL, ON KOB 1R0

Contact Name

Vendor Phone

613 678 3957

Vendor Fax

613 678 3956

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr Terms

10127-2607 Net 10

CAD

Currency FOB

Destination-Collect

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CANADA

	Line Nbr Reference Revision ID Vendor Part Number	Descr Mfg I	iption/ D	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price \$13.6000	Extende Pric S4,080 (
	D2230-3P	LUG		5/17/2013 Yes	300.00 Each	- TINGK		
2	D2230-3P	LUG	Special Inst:	AS PER DWG I B101450 5/20/2013 Yes	02230 REV. G 300.00 Each	Dart Truck	\$13.6000	\$4,080.0
3	D2230-1P	LUG	Special Inst:	AS PER DWG D B101495 5/17/2013 Yes	320.00 Each	Dart Truck M 200	\$18.9500	\$6,064 (
4 .	D3235-1P	lug	Special Inst:	AS PER DWG D2 B101834	2230 REV. G			

lug

5/17/2013

Yes

200.00 Dart Truck Each

\$15.0500

No substitution or deviation without consent. Certificate of Conformity or Material Certification required - YES

Change Nbr:

Change Date: 5/14/2013